

# **LOCTITE®**

## **EQUIPMENT** **Operation Manual**



### **Loctite® Hysol™ 050 Hot Melt Applicator**

**120 Volt Part No. 98544, 230 Volt Part No. 98546**

### **Loctite® Hysol™ 050-HT Hot Melt Applicator**

**120 Volt Part No. 98545, 230 Volt Part No. 98547**

Henkel

## SAFETY INSTRUCTIONS

**Do not touch the nozzle or molten adhesive with bare skin as they are hot – the operating temperature of the Loctite® Hysol™ 050 and Loctite® Hysol™ 050-HT is approximately 400°F (200°C). Protective gloves should always be worn. Careless handling can cause skin burns.** If molten adhesive comes into contact with the skin, immerse the affected area immediately in plenty of cold water. Seek medical advice if necessary.

In addition to the safety instructions herein, any statutory regulations, local fire insurance regulations, or other generally valid “regulations for accident prevention” must be complied with when using this tool.

- Never use the tool if it is damaged in any way.
- Do not use this tool in damp rooms, outdoors while it is raining, or where there is high humidity.
- Do not use this tool in the vicinity of any heat-sensitive materials, or any flammable materials, liquids, or gases.
- Only use extension cables that meet the specification shown in “Technical data.”
- Never pull on the tool’s connecting cable.
- This tool should only be used by children under strict adult supervision.

**BOND • SEAL • ASSEMBLE • INSULATE • REINFORCE • ENCAPSULATE • REPAIR • FILL – INSTANTLY**

The Loctite® Hysol™ 050 and Loctite® Hysol™ 050-HT Hot Melt Applicators are easy to operate, just plug into a 120 VAC power supply and the applicator will be ready for use in 5 minutes. Glue sticks can be fed continuously through the back of the applicator. Use only genuine Loctite® brand Hysol® adhesive glue sticks.

Suitable for use with most materials. Apply Loctite® Hysol® hot melt adhesive to one surface, press parts together, and the bond is made. Can be used for bonding: wood, paper, cardboard, foam, chipboard, hardboard, some plastics, rubber, glass, thin metals, ceramics, leather, fabrics, and much more.

## USING THE Loctite® Hysol™ 050 and Loctite® Hysol™ 050-HT Hot Melt Applicators

Before using the tool for the first time:

1. Check it carefully for signs of external damage. If any transit damage is found DO NOT USE THE TOOL – return it to your supplier immediately.
2. Attach the enclosed metal side-stand/hanger, locating the hooks into the holes on either side of the casing. When correctly assembled, the side-stand should pivot.
3. Either attach the plastic tool-stand by sliding it into the slot at the base of the tool handle, or for a more permanent fixture, screw the tool-stand to a convenient position on your work surface, then slide the tool onto this fixed stand.
4. Insert a Loctite® Hysol® hot melt adhesive stick into the rear of the tool. Push the stick forward until slight resistance is felt.

### Normal use:

- Place the tool in a safe position, either resting on its side using the side-stand provided, standing upright on a flat surface, or suspended via the hanger facility.
- Plug the tool into the power supply socket, and switch on the power. The power indicator light on the top of the tool will illuminate.
- Wait 4-5 minutes for the tool to reach its normal operating temperature.
- Squeeze the trigger to advance the glue stick and extrude molten adhesive through the nozzle.
- To stop extruding adhesive simply release the trigger.

When the adhesive can no longer be extruded from the tool, it is time to load another glue stick.

Once the gluing task is completed, place the tool in an upright position on a flat surface (always use the stand when resting the tool). Ensure that the nozzle cannot cause any damage to surrounding materials. Switch off the power, and allow the tool to fully cool down before packing it away. Never wrap the power lead around a tool that has not fully cooled. Any unused portion of the glue stick can remain in the tool. It will be fully reusable when re-heated.

## PREVENTATIVE MAINTENANCE

- When in use, do not lay the tool on its side unless using the metal side-stand provided.
- Do not use excessive force on the trigger. Ensure that the tool has fully warmed up before use.
- Keep the nozzle clean to prevent adhesive build-up. This is easily done by wiping the nozzle with clean paper or cloth while the nozzle is still warm.
- Should “glue backup” or “meltback” accidentally occur (when molten adhesive becomes visible at the point where the glue stick enters the heater tube), switch off the tool and allow the adhesive to cool. Gently pull away the excess adhesive, reconnect the power, and allow the tool, to warm up again. Now squeeze the trigger two or three times to advance the glue stick, then use the tool as normal.
- If the tool is going to be left idle for 30 minutes or more, the tool should be unplugged.

## APPLICATION HINTS

As with all adhesives, performance depends on conditions of use. Suggestions or recommendations contained herein are for guidance only, since actual conditions of use are outside the supplier's control.

- Ensure that the surfaces to be bonded are dry, free from dust, grease, and loose particles.
- Apply adhesive to one surface only. Bring the two surfaces together immediately, quickly making any further adjustments. Hold the joint for 20 - 30 seconds to complete the bond.
- When gluing dissimilar materials, apply the adhesive to the least heat conductive of the two.
- On materials that are cold to the touch, a better bond can be made by pre-warming them before applying adhesive.
- Surplus adhesive can be trimmed using a sharp knife once it has cooled. Should molten adhesive drip onto a smooth or polished surface, allow it to cool completely before removal.
- Spots or blobs of adhesive are recommended for work pieces having a large surface area, or which are particularly long.
- Applying the adhesive in wavy lines is recommended for gluing textiles or similar materials.
- Foam materials, like polystyrene, can be easily bonded to other surfaces. However the adhesive must be applied to the other surfaces, not to the foam.
- Use only genuine Loctite® Hysol® hot melt adhesive sticks to ensure reliable performance. Loctite® Hysol® hot melt adhesive sticks are non-toxic and non-flammable.

## REPLACING THE NOZZLE

**Only replace the nozzle while the tool is still warm. Disconnect the tool from the power supply before proceeding, and always use protective gloves.**

Remove the rubber safety cover from the nozzle. Unscrew the nozzle from the tool using a 13 mm spanner (such as that in the plastic tool-stand). Fit the replacement nozzle, ensuring that it is securely tightened. Replace the rubber safety cover.

## SERVICING AND REPAIRS

The Loctite® Hysol™ 050 and Loctite® Hysol™ 050-HT Hot Melt Applicator contain no user-serviceable parts. In order to avoid a hazard, any servicing or repairs, including replacement of the supply cord, should only be carried out by the manufacturer, its service agent, or other similarly qualified person. The tool should be disconnected from the electrical supply before any servicing or repair work is undertaken.

## TECHNICAL DATA

Dimensions (L x H x W):	10 1/4" x 7 1/2" x 3" (approx. 260 x 190 x 77 mm)
Total weight:	1 1/2 lbs. (approx. 670g)
Connection cable with mains plug:	78" long (1.8 m)
Operating voltage:	98544/98545: 120 VAC 50/60Hz 98546/98547: 230 VAC 50/60Hz
Power consumption:	approx. 250 W
Heating up time:	4-5 min.
Operating temperature:	Hysol® 050 approx. 383°F (195°C) Hysol® 050-HT approx. 419°F (215°C)
Diameter of adhesive inlet: (Use only genuine Loctite® Hysol® hot melt adhesive sticks)	1/2" (12 mm)
Extension cable:	max. 65 ft long (20 m)
Wire cross section:	at least 16 a.w.g. (1.5 mm²)

## Loctite® Brand Optional Nozzles:



## Warranty

Henkel Corporation expressly warrants that all products referred to in this Instruction Manual for the Loctite® Hysol™ 050 and Loctite® Hysol® 050-HT Hot melt Applicators (hereafter called "Products") shall be free from defects in materials and workmanship. Liability for Henkel shall be limited, as its option, to replacing those Products which are shown to be defective in either materials or workmanship or to credit the purchaser the amount of the purchase price thereof (plus freight and insurance charges paid therefor by the user). The purchaser's sole and exclusive remedy for breach of warranty shall be such replacement or credit.

A claim of defect in materials or workmanship in any Products shall be allowed only when it is submitted in writing within one month after discovery of the defect or after the time the defect should reasonably have been discovered and in any event, within 12 months after the delivery of the Products to the purchaser. This warranty does not apply to perishable items, such as fuses etc. No such claim shall be allowed in respect of products which have been neglected or improperly stored, transported, handled, installed, connected, operated, used or maintained. In the event of unauthorized modification of the Products including, where products, parts or attachments for use in connection with the Products are available from Henkel, the use of products, parts or attachments which are not manufactured by Henkel, no claim shall be allowed.

No Products shall be returned to Henkel for any reason without prior written approval from Henkel. Products shall be returned freight prepaid, in accordance with instructions from Henkel.

NO WARRANTY IS EXTENDED TO ANY EQUIPMENT WHICH HAS BEEN ALTERED, MISUSED, NEGLECTED, OR DAMAGED BY ACCIDENT, OR IF THE SYSTEM USED TO DISPENSE ANY LIQUID MATERIAL OTHER THAN LOCTITE® BRAND PRODUCTS.

EXCEPT FOR THE EXPRESS WARRANTY CONTAINED IN THIS SECTION, HENKEL MAKES NO WARRANTY OF ANY KIND WHATSOEVER, EXPRESS OR IMPLIED, WITH RESPECT TO THE PRODUCTS.

ALL WARRANTIES OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, AND OTHER WARRANTIES OF WHATEVER KIND (INCLUDING AGAINST PATENT OR TRADEMARK INFRINGEMENT) ARE HEREBY DISCLAIMED BY HENKEL AND WAIVED BY THE PURCHASER.

THIS SECTION SETS FORTH EXCLUSIVELY ALL OF LIABILITY FOR HENKEL THE PURCHASER IN CONTRACT, IN TORT OR OTHERWISE IN THE EVENT OF DEFECTIVE PRODUCTS.

WITHOUT LIMITATION OF THE FOREGOING, TO THE FULLEST EXTENT POSSIBLE UNDER APPLICABLE LAWS, HENKEL EXPRESSLY DISCLAIMS ANY LIABILITY WHATSOEVER FOR ANY DAMAGES INCURRED DIRECTLY OR INDIRECTLY IN CONNECTION WITH THE SALE OR USE OF, OR OTHERWISE IN CONNECTION WITH, THE PRODUCTS, INCLUDING, WITHOUT LIMITATION, LOSS OF PROFITS AND SPECIAL, INDIRECT OR CONSEQUENTIAL DAMAGES, WHETHER CAUSED BY NEGLIGENCE FROM HENKEL OR OTHERWISE.



**Henkel Corporation**  
**Industry and Maintenance**  
**1001 Trout Brook Crossing**  
**Rocky Hill, CT**  
**U.S.A.**

**www.henkel.us**  
**www.loctite.com**

**U.S.A.**  
**Henkel Corporation**  
Industry and Maintenance  
1001 Trout Brook Crossing  
Rocky Hill, Connecticut 06067

**Henkel Corporation**  
Automotive  
32100 Stephenson Highway  
Madison Heights, Michigan 48071

**Canada**  
**Henkel Canada Corporation**  
Industry and Maintenance  
2225 Meadowpine Blvd.  
Mississauga, Ontario L5N 7P2

**Mexico**  
**Henkel Capital S.A. de C.V.**  
Boulevard Magnocentro No. 8 Piso 2  
Centro Urbano Interlomas  
52760 Huixquilucan, Estado de México

**South America**  
**Henkel Ltda.**  
Rua Karl Huller, 136 - Jd.  
Canhema 09941-410